

A heat-sealing device moves a tube-shaped packaging material through operation of a seal jaw and counter jaw under the liquid surface of liquid food, and heat-seals a seal zone containing a cutting predetermined zone in the tube transverse direction. The tube-shaped packaging material is formed from the packaging material web, and is filled up with liquid food. The operation surface of the seal jaw facing the seal zone has a substantially flat surface. The heat-sealing device has a removal/mixture mechanism on the operation surface of the counter jaw. The removal/mixture mechanism removes seal prevention impurity from this seal zone and/or mixes the impurity with the melting/softening packaging material in this seal zone. Thus, even if the packaging laminated material is covered with an oxide, residual substances, or impurities, the heat-sealing device reduces the bad influence of the seal prevention impurity.

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